

Work Order ID 68168

Thursday, April 07, 2011 12:10:15 PM



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Item ID: D3552-28 21

Accept



Setup Start



Revision ID:

Item Name: Door Prop

Start Date: 4/7/2011 Start Qty: 1.00



Required Date: 4/7/2011 Req'd Qty: 1.00



Cust Item ID:

Customer:

**PRELIMINARY
ISSUE**



Reference:

Approvals:

Process Plan: CD

Date: 11/04/07

Tooling:

Date:

Run Start



QC: _____

Date: _____

SPC (Y/N):

Date: _____

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr	Revision Nbr
D3552	PH2

100



PURCHASING

Purchasing

Memo

0.00

0.00

CD 11/04/07 ①

Purchasing

Issue P/O: 13824

Purchase Part Number: B6-167-408-070N

Supplier: LS Technologies

Certificate of conformity is required

110



Receive & Inspect for Damage & Mat'l Certs

0.00

CD 11/04/13 ①

Packaging

Memo

0.00

Packaging

Ensure certificate of conformity is attached

120



QC6- Inspect dimensions to drawing

0.00

QC

Memo

0.00

Quality Control

Test for correct pressure

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 68168

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Thursday, April 07, 2011 12:10:15 PM

Item ID: D3552-25 *J*

Accept



Setup

Start



Revision ID:

Item Name: Door Prop

Stop



Start Date: 4/7/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 4/7/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run

Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center ID

130



Packaging

Packaging

Operation
Description

Identify as per dwg & Stock Location: _____

Set Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

0.00

Ship direct

0.00

*to Cagle**attn: Dawn Campbell*

140



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

CL 11/04/19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action - Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 1

Thursday, April 07, 2011 12:10:12 PM

Work Order ID: 68168



Parent Item: D3552-232



Parent Item Name: Door Prop

Start Date: 4/7/2011

Required Date: 4/7/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 11.04.07 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
B6-167-408-070N CARBON STEEL GAS SPRING		Purchased		No		110	Each	0.0000	1	1		4/7/13	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 68168



Page 1

Thursday, April 14, 2011 9:56:57 AM

Item ID: D3552-2821

Accept



Setup Start

Stop

Revision ID:

Item Name: Door Prop

Start Date: 4/7/2011 Start Qty: 1.00

Cust Item ID:

Required Date: 4/7/2011 Req'd Qty: 1.00

Customer:

Reference:

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start
	QC:	Date:	SPC (Y/N):	Date:	Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3552	G

100	0.00
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	PURCHASING
--	------------

Purchasing	Memo	0.00
Purchasing	Issue P/O: <i>410</i>	
	Purchase Part Number: B6-167-408-070N	
	Supplier: LS Technologies	
	Certificate of conformity is required	

110	Receive & Inspect for Damage & Mat'l Certs	0.00
-----	--	------

	Packaging	Memo	0.00
Packaging	Ensure certificate of conformity is attached		

120	QC6- Inspect dimensions to drawing	0.00
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	QC	Memo	0.00
Quality Control	Test for correct pressure		

11.04.19

Work Order ID 68168

Thursday, April 14, 2011 9:56:57 AM



Page 2

Item ID: D3552-28 Z1 ~~44~~

Accept



Setup Start



Revision ID:

Item Name: Door Prop

Stop



Start Date: 4/7/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 4/7/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____

Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____

SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

Packaging

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

L11/04/19



303 - 103rd Street, Saskatoon, Saskatchewan, Canada S7N 1Y9
Ph: (306) 683-5000 Fax: (306) 683-6403

Certificate of Compliance

This is to certify that the parts listed below meets specifications as required by your order.

1 Unit: B6-167-410-070N Gas Spring (D3552-28) Carbon Steel Gas Spring

-21 ~~11~~ 11.04.19

Country of Manufacture: Canada
Date of Manufacture : April 2011
This product is ROHS compliant.

We certify no mercury was used in the manufacture of this order.

Purchase Order # 13824
Invoice # 7153

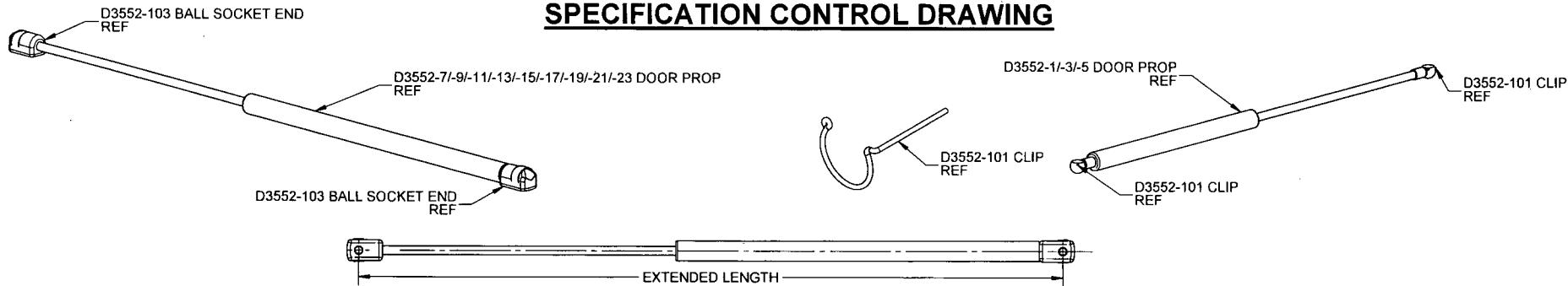
L S Technologies Inc Canada

A handwritten signature in black ink, appearing to read "N Fehr".

Nolan Fehr
Manager

8 7 6 5 4 3 2 1

SPECIFICATION CONTROL DRAWING



DART PART NUMBER	DESCRIPTION	STROKE (mm/in)	EXTENDED LENGTH (mm/in)	FORCE (N/lb)	END FITTING	MATERIAL	SUPPLIER	SUPPLIER PART NUMBER OR MODEL NUMBER	ALTERNATE SUPPLIER	ALTERNATE SUPPLIER P/N OR MODEL NUMBER
D3552-1	DOOR PROP	220/8.66	530/20.6	70/15.7	10mm SS BALL SOCKET	CARBON STEEL	LS TECHNOLOGIES	C8-220-530-070N	N/A	N/A
D3552-3	DOOR PROP	200/7.87	490/19.3	200/45.0	10mm SS BALL SOCKET	CARBON STEEL	LS TECHNOLOGIES	C8-200-490-200N	N/A	N/A
D3552-5	DOOR PROP	175/6.89	430/16.9	150/33.7	10mm SS BALL SOCKET	CARBON STEEL	LS TECHNOLOGIES	C8-175-430-150N	N/A	N/A
D3552-7	DOOR PROP	220/8.66	530/20.9	70/15.7	10mm NYLON BALL SOCKET	CARBON STEEL	LS TECHNOLOGIES	B8-220-530-070N	N/A	N/A
D3552-9	DOOR PROP	200/7.87	490/19.3	200/45.0	10mm NYLON BALL SOCKET	CARBON STEEL	LS TECHNOLOGIES	B8-200-490-200N	N/A	N/A
D3552-11	DOOR PROP	240/9.45	575/22.6	150/33.7	10mm NYLON BALL SOCKET	CARBON STEEL	LS TECHNOLOGIES	B8-240-575-150N	N/A	N/A
D3552-13	DOOR PROP	220/8.66	530/20.9	140/31.5	10mm NYLON BALL SOCKET	CARBON STEEL	LS TECHNOLOGIES	B8-220-530-140N	N/A	N/A
D3552-15	DOOR PROP	139/5.47	386/15.2	300/67.4	10mm NYLON BALL SOCKET	CARBON STEEL	LS TECHNOLOGIES	B8-154-387-300N	SUSPA, Inc.	16-2-210-139-A101-B101-400N
D3552-17	DOOR PROP	139/5.47	386/15.2	156/35.1	10mm NYLON BALL SOCKET	CARBON STEEL	LS TECHNOLOGIES	B8-154-387-156N	SUSPA, Inc.	16-2-210-160-A101-B101-156N
D3552-19	DOOR PROP	139/5.47	386/15.2	60/13.5	10mm NYLON BALL SOCKET	CARBON STEEL	LS TECHNOLOGIES	B8-154-387-060N	SUSPA, Inc.	16-2-210-139-A101-B101-060N
D3552-21	DOOR PROP	200/7.87	490/19.3	70/15.7	10mm NYLON BALL SOCKET	CARBON STEEL	LS TECHNOLOGIES	B8-200-490-070N	N/A	N/A
PH-2	D3552-23	DOOR PROP	167/6.57	408/16.1	70/15.7	10mm NYLON BALL SOCKET	CARBON STEEL	B6-167-408-070N	N/A	N/A
3	D3552-101	CLIP	N/A	N/A	N/A	CARBON STEEL	LS TECHNOLOGIES	C9	N/A	N/A
	D3552-103	BALL SOCKET END	N/A	N/A	N/A	NYLON	LS TECHNOLOGIES	B10	N/A	N/A

D3552-X DOOR PROP

*Slp Eng 6
Att Dan Campbell*

PRELIMINARY ISSUE

DC 11.03.10

NOTES:

- 1) IDENTIFICATION: IDENT P/N D3552-X & B/N PER QSI 044 6.2
- 2) D3552-101 CLIP IS ONLY COMPATIBLE WITH D3552-1/3-5 DOOR PROPS
- 3) D3552-103 BALL SOCKET END IS ONLY COMPATIBLE WITH D3552-7-9-11-13-15-17-19-21-23 DOOR PROPS

PH-2	ADD P/N D3552-21-23	DC	11.03.10
G	FOR -15, FORCE:300/67.4 WAS 400/89.9, SUPPLIER P/N B8-154-387-300N WAS B8-154-387-400N; FOR -17, STROKE: 139/5.47 WAS 160/6.30, EXT LG: 386/15.2 WAS 407/17.0, SUPPLIER P/N B8-154-387-156N WAS B8-167-408-156N	JPH	10.11.01
F	ADD P/N D3552-15-17-19 AND ALTERNATE SUPPLIER	JPH	10.07.27
E	ADD P/N D3552-13 ZN B8-1, A8-1, D6-1, CHANGE NAME FROM "GAS SPRING" TO "DOOR PROP" THROUGH OUT DWG	HS	10.02.03
D	ADD P/N D3552-101 ZN D6-1, C7-1, C1-1 AND D3552-103 ZN D1-1 AND C2-1 AND ZN B8-1; ADD NOTE REGARDING D3552-101 AND D3552-103 COMPATIBILITY ZN A8-1	HS	09.04.02
C	ADD D3552-11 AND CONVERSIONS FOR INSPECTION; UPDATE PIN FOR D3552-7	LE	07.06.01
B	ADD D3552-7-9; UPDATE DESC. D3552-1/-3/-5	LE	06.10.24
A	NEW ISSUE	LE	06.09.15
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>CE</i>	DART AEROSPACE LTD	
DRAWN	<i>DC</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>DC</i>	DRAWING NO.	REV. PH-2
MFG. APPR.	N/A	D3552	SHEET 1 OF 1
APPROVED		TITLE	
DE APPR.		DOOR PROP	NTS
DATE	11.03.10	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

8 7 6 5 4 3 2 1



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO13824**

Purchase Order Date 4/7/2011
PO Print Date 4/7/2011

Page Number 1 of 1

Order From : VC-LST0001

LS TECHNOLOGIES INC.
303-103 STREET
SASKATOON, SK S7N 1Y9
CA

Contact Name

Vendor Phone 306 683 5000

Vendor Fax 306 683 6403

Vendor Account Nbr

Buyer

Chantal Lavoie

Requisition Nbr

10127-2607

Tax Resale Nbr

Net 30

Terms

CAD

Currency

FOB

Destination-Collect

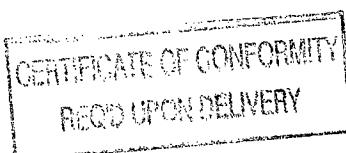
Ship To : EAGLE COPTER 823 MCTAVISH
CALGARY, AB
CANADA

FAXED
4/10/07

Line Nbr	Reference Revision ID	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
Vendor Part Number							
1	B6-167-408-070N	CARBON STEEL GAS SPRING	4/7/2011	1.00	Each	\$32.5000	\$32.50

Special Inst: AS PER DWG D3552 REV. G
B68168
PLEASE SHIP DIRECT TO EAGLE
COPTERS
ATTN: DANIEL CAMPBELL

PO Total: \$32.50



No substitution or deviation without
consent.

Certificate of Conformity or Material
Certification required when applicable

Change Nbr: 1

Change Date: 4/7/2011

LS Technologies Canada Inc.
303 - 103 Street
Saskatoon, SK Canada
S7N 1Y9

Invoice

Date	Invoice #
4/7/2011	7153

Invoice To
Dart Aerospace Ltd 1270 Aberdeen St. Hawkesbury, ON K6A 1K7

Ship To
Eagle Copters 823 McTavish Road Calgary, AB T2E 7G9 Att: Dan Campbell

P.O. No.	Terms	Rep	Ship Via
PO13824	Net 30	Ngian	Fed-Ex

Description	Qty	Rate	Amount
B6-167-410-070N Gas Spring (D3552-23)	1	32.50	32.50
Shipping Via FED EX to Eagle Copters Tracking #796961972315		0.00	0.00
Please Pay by Invoice: No Statement Issued.			
		GST/HST	CAD 4.23

ALL RETURNED GOODS REQUIRE PRIOR APPROVAL & RMA # . RETURNS
WITHOUT AN RMA# WILL NOT BE ACCEPTED OR CREDITED
Interest charges of 2% per month on overdue accounts.
We appreciate your business. Thank you !

Total

CAD 36.73

Phone #	Fax #	LS Technologies E-mail
(306) 683-5000	(306) 683-6403	info@lstechnologies.ca

GST/HST No. 875007718



303 – 103rd Street, Saskatoon, Saskatchewan, Canada S7N 1Y9
Ph: (306) 683-5000 Fax: (306) 683-6403

Certificate of Compliance

This is to certify that the parts listed below meets specifications as required by your order.

1 Unit: B6-167-410-070N Gas Spring (D3552-23) Carbon Steel Gas Spring

Country of Manufacture: Canada
Date of Manufacture : April 2011
This product is ROHS compliant.

We certify no mercury was used in the manufacture of this order.

Purchase Order # 13824
Invoice # 7153

L S Technologies Inc Canada

Nolan Fehr
Manager